

Date: Monday, 5/15/2006 11:10:44 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 27105	
Estimate Number : 11376	
P.O. Number : N/A	Part Number : D33872
This Issue : 5/15/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 5/15/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 26671	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/30/2006
Checked & Approved By : <u>06.05.15</u>	Qty: 20 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total: 31.3593 f(s)
6061-T6 Bar .50" x 6.0"
Material: 6061-T6/T651 (QQ-A-200/8)
(M6061T6B0.500x06.000)
Identify for D3387-2
Batch: M101092

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank: 6.000" x 0.500" x 17.800" long

JL 06/05/28 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA512 and Dwg D3387
Identify as D3387-2
Tumble and Deburr NO sharp edges

JL 06/05/28 20


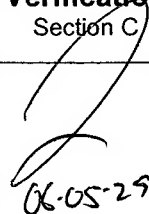
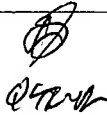
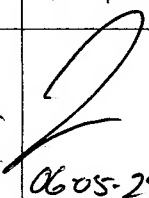
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
C'sink Ø0.375" as per Dwg D3387

06/05/29 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/28	3	- 1 part scrap - forgot to run with "optional step on" - part vibrated and is too thin		- scrap & replace	J.L. 06/05/28	 06-05-29		 06-05-29

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/05/31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:10:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27105

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/05/29 20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EN 06/05/29 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 56

PAT 500000

P64/07/30 20

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

28 06/05/31

Job Completion



U 06/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27105
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.508	✓			
7.577	+/-0.010	7.584	✓			
R0.030	+/-0.010	5.030	✓			
Ø0.191	+0.005/-0.000	.192	✓			
1.700	+/-0.010	1.701	✓			
0.188	+/-0.010	.186	✓			
11.405	+/-0.010	11.405	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
2.033	+/-0.005	2.033	✓			
R0.300	+/-0.010	5.300	✓			
1.000	+/-0.005	1.000	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.005	1.349	✓			
0.250	+/-0.010	.249	✓			
R0.125	+/-0.010	5.125	✓			
0.125	+/-0.010	.131	✓			
R0.032	+/-0.010	5.032	✓			
Ø0.375 x100°	+/-0.010					
0.500	+/-0.010	.494				
0.300	+/-0.010	.299				

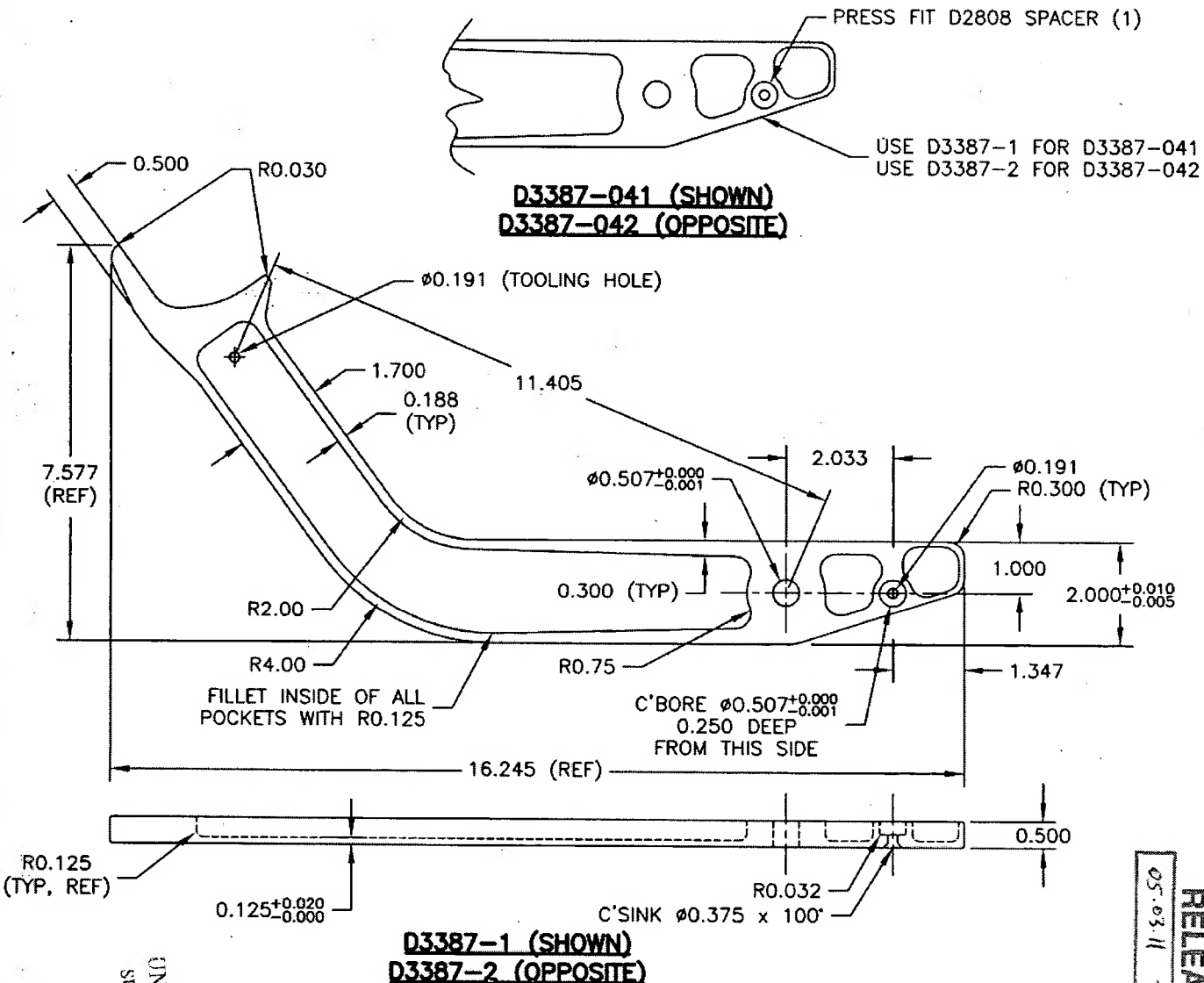
Measured by:	JL	Audited by:	MS	Prototype Approval:	N/A
Date:	06/05/27	Date:	06/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3387	SHEET 1 OF 1
05.01.18		TITLE	SCALE
A	05.01.18	ARM	1:3
		NEW ISSUE	

05.03.11



GENERAL NOTES

D3387-2 (OPPOSITE)

GENERAL NOTES

MACHINE PER DRAWING FILE "D3387-A.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)

DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 27105
WORK ORDER

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